

Date: Monday, 9/17/2007 1:49:12 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206 EXTRUSION BENDING
 Job Number : 34693
 Estimate Number : 10311
 P.O. Number : *N/A* Part Number : D2620
 This Issue : 9/17/2007 S.O. No. : *N/A* Drawing Number : D2620 REV B
 Prsht Rev. : NC Project Number : *N/A*
 First Issue : *N/A* Type : LANDING GEAR Drawing Revision : B
 Previous Run : 34692 Material : *N/A*
 Written By : Due Date : 10/12/2007 Qty: 30 Um: Each
 Checked & Approved By : *07.09.17*
 Comment : Est. D 02.07.26 Change Dwg to rev.B; Updated Location RF

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D26001160 Extrusion Round 3" 206



Comment: Qty.: 1.0000 Each(s)/Unit Total : 30.0000 Each(s)

Extrusion Round 3" 206

Pick;

Qty Part Number Description Batch
 1 D2600-1 Extrusion Round 3"206 *B30249*

EL 7-11-6

2.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Bend extrusion as per Dwg D2620 using CNC Bending Machine program 206.A
 and Folio Ft008

2- Cut Fwd end of tube as per Dwg D2620

EL/SR 7-11-6

3.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BE 07-11-07

4.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *LG*

BE 07-11-07

30.

5.0 QC21 FINAL INSPECTION/W/O RELEASE



(30)

Comment: FINAL INSPECTION/W/O RELEASE

07/11/09

Job Completion



W St. 07-08

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DD Date: 9/16/09
 QA: N/C Closed: _____ Date: _____

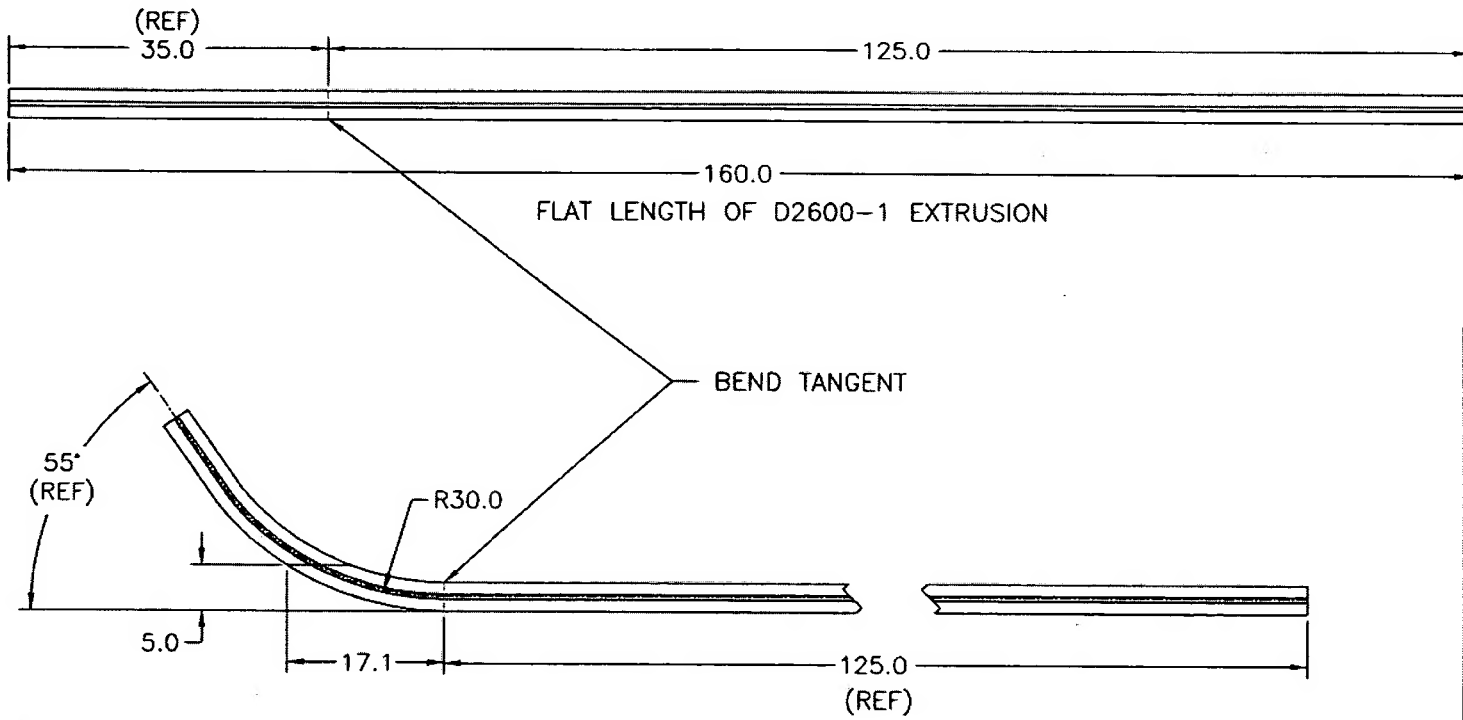
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SPECIFICATION CONTROL DRAWING

206 SKIDTUBE BENDING

DART



DAMAGE TOLERANCE

1. THERE SHOULD BE NO VISIBLE WRINKLES BELOW 5.0" AFTER BENDING.
2. GOUGES UP TO 0.020 DEEP ARE ACCEPTABLE IN BENT PORTION OF THE TUBE. NO GOUGES ARE ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. DEEPER GOUGES ARE ACCEPTABLE IN THE PORTION OF THE TUBE ABOVE 5.0.
3. TUBE WIDTH SHOULD BE 3.20 ± 0.200 IN THE BEND. TUBE WIDTH, SHOULD BE 3.200 ± 0.010 IN THE FLAT PORTION OF THE TUBE.
4. TUBE HEIGHT SHOULD BE 3.15 ± 0.200 IN THE BEND. TUBE HEIGHT SHOULD BE 3.150 ± 0.010 IN THE FLAT PORTION OF THE TUBE.

NOTE: ALL DIMENSIONS ARE IN INCHES

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CHECKED	APPROVED	FAIRCHILD INTERNATIONAL AIRPORT, WA
DATE	DATE	TITLE
99.09.10	97.11.07	206 SKIDTUBE BENDING CONTROL
A	97.09.10	NEW ISSUE
B		UPDATE FOR IN-HOUSE BENDING

RELEASED
44.04.15 DS

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NO. 34693
 WORK ORDER
 WITHOUT NOTICE
 UNCONTROLLED COPY
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 ENGINEERING
 RETURN TO
 SHOP COPY

